Work	Orde	r ID	53814	1
------	------	------	-------	---

Α

Required Date: 25/11/2009



Page 1

November 18, 2009 1:46:57 PM

Item	ID:
------	-----

D3175-3

Spacer

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

18/11/2009

Start Qty: 10.00 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date 09-11-18

Tooling:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Draw Nbr

Operation **Description** Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Insp.

Number Stamp

D3175

Rev A

Revision Nbr

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 2.125" x 1.250"

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS CNC vertical machine #1

Machine as per Folio FA294 and Dwg D3175□Deburr and Tumble□Identify as

D3175-3

Memo

120

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

0.00

18/1/80 From

Memo

0.00

Quality Control

W/O:	•		W	ORK ORDER CHANG	ES					·	
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								-			
				-							
Part No:P		PAR #:	Fault Ca	legory:	NCR: Yes No DQA: Date:						
			Disposition: (QA: N/C Closed: Date: _					
NCR:			WORK OR	DER NON-CONFORMA	ANCE (I	ICR)			_		
DATE	STEP	Description of NC	Corrective Action Section			Cian e Verit			Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		ogn & Date	Section	on C	Chief Eng	QC Inspector	
-											
			,							·	

Work Order ID 53814 November 18, 2009 1:46:57 PM

Α



Page 2

Item ID:

D3175-3

Setup Start

Stop



Revision ID: Item Name:

Spacer

Required Date: 25/11/2009

18/11/2009

Start Oty: 10.00 Rea'd Otv: 10.00

Cust Item ID:

Customer:

Draw

Number

Reference:

Start Date:

Approvals:

Process Plan: Date:

Tooling:

Accept

Date:

Draw

Rev.

Run

Start



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

130

OC

Ouality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00

Jul ogli/27

Plan

Code

Oty

Reject

Reject Number

Insp. Stamp

Chemical Conversion Coat per OSI005 4.1

0.00

mp 09/11/30

Accept

Qty

140

HandFinish

Hand Finishing

Memo

0.00

QC3- Inspect Part Finish

0.00

BK 09 11- 30

XID _____

150

Quality Control

Memo

0.00

Dart Ae	rospace	Ltd							ų	
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		a ·						3 15 15 184		
901										
Part No	:	PAR #:	Fault Category:	NC	R: Yes	A:	Date:			
	Re	esolution:	Disposition:	QA	: N/C CI	osed:		Date:		
NCR:			WORK ORDER NON-CON	FORMANCE	(NCF	R)	•	<u> </u>		
DATE	STEP	Description of NC	Corrective Action Des	n Section B	Sign 8	Verific	cation	Approval	Approval	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B		Verification	Approval	Ammayal						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector						
							-							
								· ·						

Work Order ID 53814

Α

Page 3

November 18, 2009 1:46:57 PM

Item ID:

D3175-3

Revision ID: Item Name:

Spacer **Start Date:**

18/11/2009

Start Qty: 10.00 Required Date: 25/11/2009

Req'd Qty: 10.00

Accept



Setup Start



Stop

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:_

Draw

Run

Start



Stop

Reject



Insp.

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Rev. Code Qty Qty

Accept

Plan

Number Stamp

Reject

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 09/12/0194/ mr 09-12-01

Dart Aerospace Ltd	J	
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W/O:	WORK ORDER CHANGES									
DATE	STEP	PROC	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·				-		
		; t	4.0	1,						
		i							·	
<u> </u>										
Part No: PAF										
Resolution:			Dispositi	on:	QA:	N/C Clos	sed:		Date:	
NCR:		· W	ORK ORI	DER NON-CONFORMA	NCE	(NCR)				•
DATE	STEP	Description of NC	Corrective Action Section				Verification	Approval	Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C		Chief Eng	QC Inspector
		•								
· • • • • • • • • • • • • • • • • • • •	٠.						•			
						· -		·		

Picklist Print

Comments:

November 18, 2009 1:47:03 PM

Work Order ID: 53814

Parent Item: D3175-3RevA

Parent Item Name: Spacer



Warehouse

Location

MAT



Start Date: 18/11/2009

Required Date: 25/11/2009

Page 1

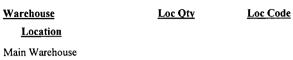
Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B0.375X01.25		Purchased	No			100	f	29.6000	1.8642			



6061-T6 Bar .375 x 1.25



29.6 17.6 110167 12 110908

1.864 JL 09/11/24

Dart Aerospace Ltd

	. Johado -													
W/O:			WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			<u> </u>											
Part No	:	PAR #:	Fault Category: NO			NCR: Yes No DQA: Date:								
•	Res	olution:	Disposition	Disposition: QA			sed:	144	Date: _					
NCR:		-	WORK ORDE	ER NON-CONFORM	MANCE (I	VCR)		*-						
DATE	STEP	Description of NC			ection B	Verific	ation	Approval	Approval					
DATE	Section A		Initial Action Descri Chief Eng Chief Eng		n Sign & Date		Section C		Chief Eng	QC Inspector				
*														
				***************************************	-									
								:						
								,						
1			1 1											

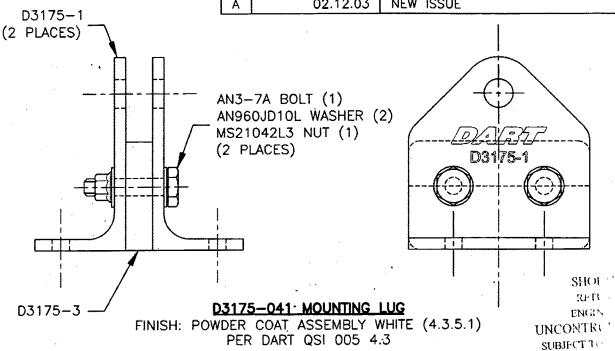
D3065-5DART AEROSPACE LTD	Work Order:	53814
Description: Spacer	Part Number:	D3175-3
Inspection Dwg: D3175 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST												
		X First Art	cle	Prot	otype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	nments					
2.000	+/-0.010	000.6					· _ ·					
0.500	+/-0.010	, 499										
1.000	+/-0.005	1.000										
Ø0.191	+0.005/-0.000	W.194										
R0.13	+/-0.030	R.13										
0.680	+/-0.010	680			_							
1.180	+/-0.010	1.179		•		· <u>-</u>						
0.285 - 0.290	N/A	186:										
							·					
						-						
		,										
		-										
Measured by:	- Z	Audited by:	+		Prototype A		N/A					
Date:	TX11/20	Date:	Oglula	27		Date:	N/A					

Rev	Date	Change		Revised by	Approved
Α	04.02.25	New Issue	P/O K10017	KJ/RF	14
	•			. ()	



DESIG	DESIGN ORAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHEC	(ED	APPROVED.	DRAWING NO. D3175	REV. A SHEET 1 OF 2	
DATE	· · · · · · · · · · · · · · · · · · ·		TITLE	SCALE	
02.1	2.03		MOUNTING LUG	1:1	
Δ		02 12 03	NEW ISSUE		



PELEASED OF ALLOS

D3175-3 SPACER

1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK

(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

(REF DART SPEC. M6061T6B)

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6 ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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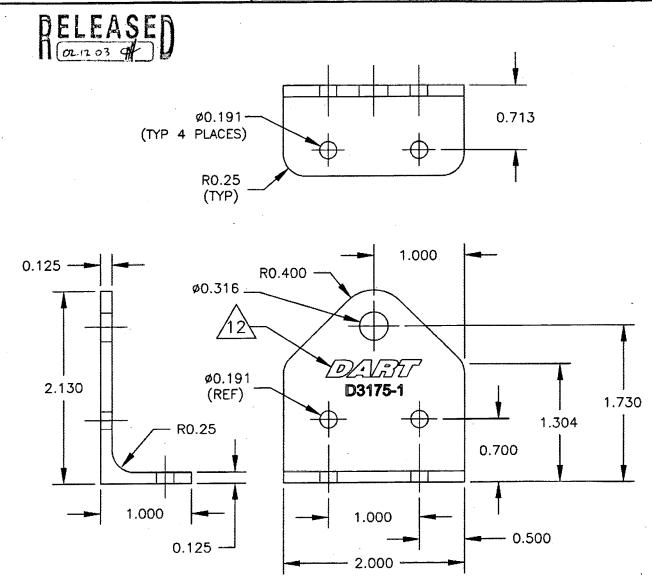
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11/0 528/4





		<u>u</u>	10000	
DESIGN (7 DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED M	APPROVED N	DRAWING NO.	REV. A	
#	#	D3175	SHEET 2 OF 2	
DATE	•	TITLE	SCALE	
02.12.03		MOUNTING LUG		



D3175-1 BRACKET

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 1,1) ALL DIMENSIONS ARE IN INCHES
- ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX